

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021436**Date Inspected:** 28-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Geng Wei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Structure**Summary of Items Observed:**

: On this date Caltrans OSM Quality Assurance (QA) Inspector ,Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

BAY 14 -14E

FLUX CORED ARC WELDING (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP3164 -001-094,097,210,213,102,105,224,227,110,113,232,235,130,133,240,243.Located on DP3164-001. The welder is identified as 044824. ZPMC Quality Control (QC) is identified as Mr. Xie Ming Feng. The welding variables recorded by QC appeared to comply with WPS-B-T-2233-ESAB.

VISUAL TESTING (VT)

This QA inspector performed random visual inspection of a total of 15 repair excavations for the longitudinal diaphragm LD3041A to Floor beam 3287A Tee joint connection at panel point 127. The weld is designated as SEG 3019Z-010 and the repairs were carried out in accordance with CWR19178. There were no visible indications present at the time of inspection.

VISUAL TESTING (VT)

WELDING INSPECTION REPORT

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This QA inspector performed random visual inspection of a total of 5 repair excavations at Floor beam 3272A Tee joint connection at panel point 127. The weld is designated as SEG 3019I-1-085 and the repairs were carried out in accordance with CWR 2645. There were no visible indications present at the time of inspection.

VISUAL TESTING (VT)

This QA inspector performed random visual inspection of a total of 5 repair excavations for the longitudinal diaphragm LD3042 to Floor beam 3287A Tee joint connection at panel point 127. The weld is designated as SEG 3019AA-002 and the repairs were carried out in accordance with CWR2774. There were no visible indications present at the time of inspection.

On this date Caltrans OSM Quality Assurance (QA) Inspector ,Mr. Manuel Teall was present during the times noted above for observations relative to the work being performed at ZPMC.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Teall,Manuel	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
